

Work Order ID 53116

October 22, 2009 10:44:20 AM



Page 1

Item ID: D3780-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Armrest Assembly

Start Date: 10/22/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 10/22/2009 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: MF Date: 09-10-22 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3780	Rev D

100 0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- assemble as per dwg D3780
****torque screws as per dwg D3780****

Handwritten: 09/10/2009 (3) RTO

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Handwritten: 2) S arlulor

Handwritten: (43) 7

120

Identify as per dwg & Stock Location: 262

0.00



Packaging

Memo

0.00

Packaging

Handwritten: 9/11/31 (3) 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3780-041 ^{→ D412-761} PAR #: N/A Fault Category: ENG. DESIGN NCR: Yes No DQA: NA Date: 09-11-06
 Resolution: Rework Disposition: Re-work QA: N/C Closed Date: 05-11-17

NCR: 53116		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/11/03	100	NOT ENOUGH CLEARANCE PROVIDED FOR SEAM ON CUSHION. Root Cause : FAILED TO BUILD A PROTOTYPE PRIOR TO DWG. APPROVAL. R.C. L O A	09/11/03	REPLACE D3785-3 WITH CUSTOM MADE Part D37853 ENG. TO REVISE D3785 DWG FROM REV.C TO D. Re-work per Eng.	09/11/03	09/11/03	09/11/03	09/11/03

NOTE: Date & initial all entries

Work Order ID 53116

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Page 2

Item ID: D3780-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Armrest Assembly

Start Date: 10/22/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 10/22/2009 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/03

ME

09-11-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 22, 2009 10:44:19 AM

Page 1

Work Order ID: 53116

Parent Item: D3780-041RevD

Parent Item Name: Armrest Assembly

Comments:

Start Date: 10/22/2009

Required Date: 10/22/2009

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3696-041RevC		Manufactured	No			100	Each	0.0000	3.0000			
Arm Assembly						B46201 (3P)					EP 09/10/22	
D3781-041RevC		Manufactured	No			100	Each	1.0000	3.0000			
Lateral Cushion Assembly											EP 09/10/22	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47992

1

1

D3781-043RevD
Armrest Cushion Assembly

Manufactured No

100

Each

3.0000

3.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

51715

3

3

D3785-3RevC
Bracket

Manufactured No

100

Each

6.0000

3.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST130

51700

6

6

B53165

B 53346

3

EP 09/10/22

3 5009/10/30
8B 09/11/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

Work Order ID: 53116

Parent Item: D3780-041RevD

Parent Item Name: Armrest Assembly







Comments:

Start Date: 10/22/2009

Required Date: 10/22/2009

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3977-1RevA  Bolt		Manufactured	No			100	Each	4.0000	3.0000 		<u>09/10/22</u>	
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>51701</div> <div>Loc Qty</div> <div>4</div> <div>4</div> <div>Loc Code</div>												
D3978-1RevA  Nut		Manufactured	No			100	Each	4.0000	3.0000 		<u>09/10/22</u>	
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST139</div> <div>51702</div> <div>Loc Qty</div> <div>4</div> <div>4</div> <div>Loc Code</div>												
D3979-1RevA  Washer		Manufactured	No			100	Each	9.0000	3.0000 		<u>09/10/22</u>	
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>51703</div> <div>Loc Qty</div> <div>9</div> <div>9</div> <div>Loc Code</div>												

October 22, 2009 10:44:19 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

October 22, 2009 10:44:19 AM

Work Order ID: 53116

Parent Item: D3780-041RevD

Parent Item Name: Armrest Assembly

Comments:

Start Date: 10/22/2009

Required Date: 10/22/2009

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD10L

Purchased

No

100

Each

5,955.000

6.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5955

101291

16

104885

153

105793

236

109632

550

110985

5000

EP 09/10/22

AN970-6

Purchased

No

100

Each

50.0000

6.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

50

10538

8

109798

42

EP 09/10/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 53116



Parent Item: D3780-041RevD



Parent Item Name: Armrest Assembly

Start Date: 10/22/2009

Required Date: 10/22/2009

Comments:

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3 		Purchased	No			100	Each	3,455.000	6.0000			
Nut												

EP 09/10/22

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

3455

110844

32

111274

35

111668

888

112314

2000

112385

500

6

MS24665-302

Purchased

No

100

Each

34.0000

3.0000



Cotter Pin

EP 09/10/22

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

34

111359

34

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53116



Parent Item: D3780-041RevD



Parent Item Name: Armrest Assembly

Start Date: 10/22/2009

Required Date: 10/22/2009

Comments:

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS24693-C272		Purchased	No			100	Each	1,448.000	6.0000			
Screw												

EF 09/10/22

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1448	
17137	519	
17831	520	
8814	3	
8815	46	
9063	60	
9370	300	

6

MS24693-C277

Purchased

No

100

Each

24.0000

6.0000



Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	24	
109297	24	

EF 09/10/22

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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October 22, 2009 10:44:19 AM

Work Order ID: 53116



Parent Item: D3780-041RevD



Parent Item Name: Armrest Assembly

Start Date: 10/22/2009

Required Date: 10/22/2009

Comments:

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149D0663J		Purchased	No			100	Each	199.0000	3.0000			
Washer												

9/30/10/22

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

199

112612

199

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

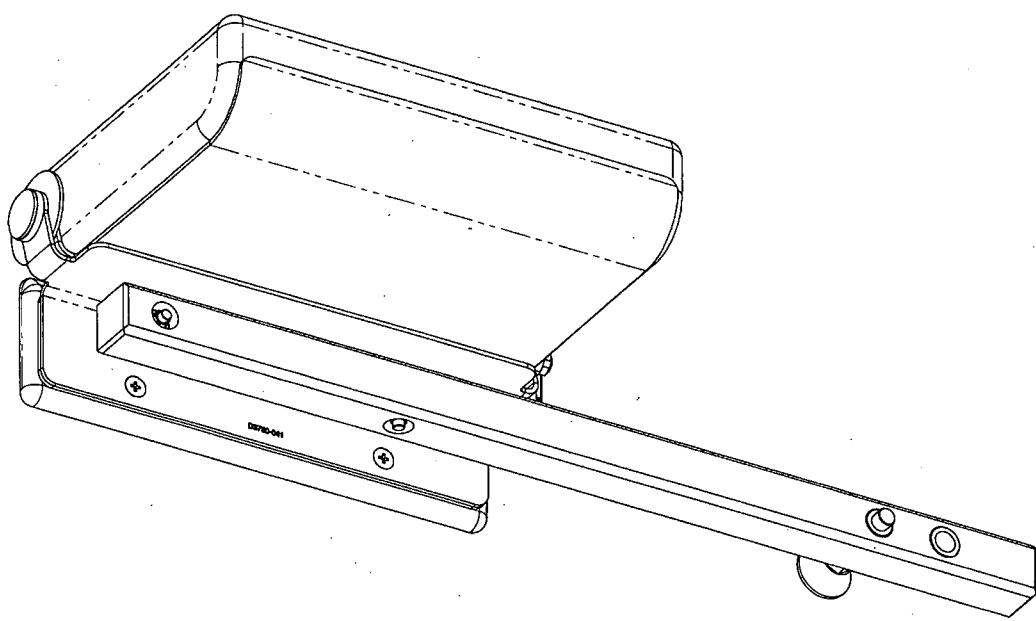
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3780-041 ARMREST ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3696-041	ARM ASSEMBLY
4	1	D3781-041	LATERAL CUSHION ASSEMBLY
5	1	D3781-043	ARMREST CUSHION BASE ASSY
6	1	D3785-3	BRACKET
7	1	D3977-1	BOLT (CARRIAGE), UNC
8	1	D3978-1	NUT (CASTELLATED), UNC
9	1	D3979-1	WASHER (SQUARE HOLE)
12	2	AN960JD10L	WASHER
13	2	AN970-6	WASHER
14	2	MS21042L3	NUT
15	1	MS24665-302	COTTER PIN
16	2	MS24693-C272	SCREW
17	2	MS24693-C277	SCREW
18	1	NAS1149D0663J	WASHER

#53116

RELEASED
09/07/21

D	REDESIGNED BASED FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.11
C	UPDATED BOM TO CURRENT STANDARDS; REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3780** REV. D
SHEET 1 OF 3
TITLE **ARMREST ASSEMBLY** SCALE NTS

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8 7 6 5 4 3 2 1

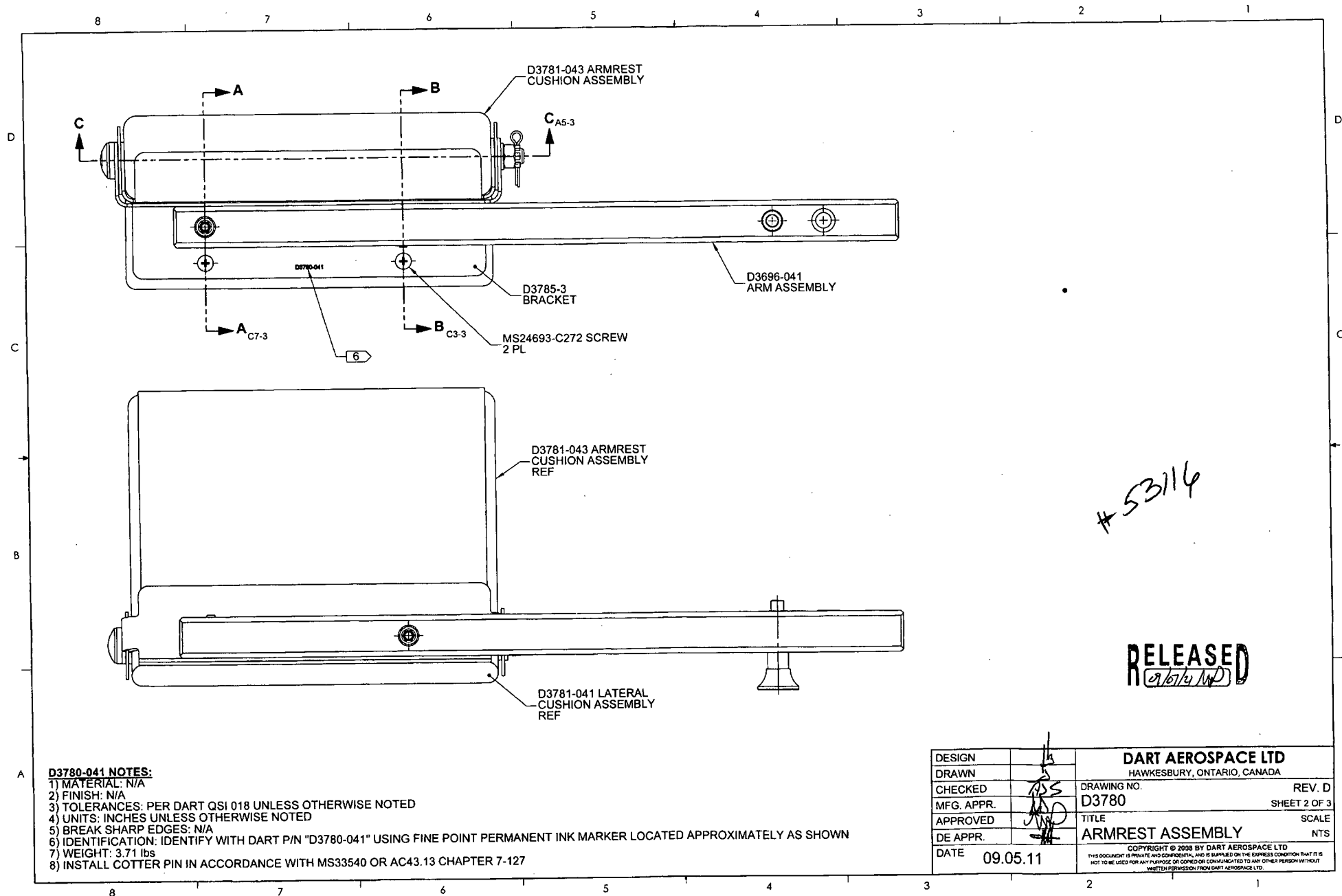
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



D3780-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3780-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 3.71 lbs
- 8) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540 OR AC43.13 CHAPTER 7-127

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3780	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	09.05.11	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

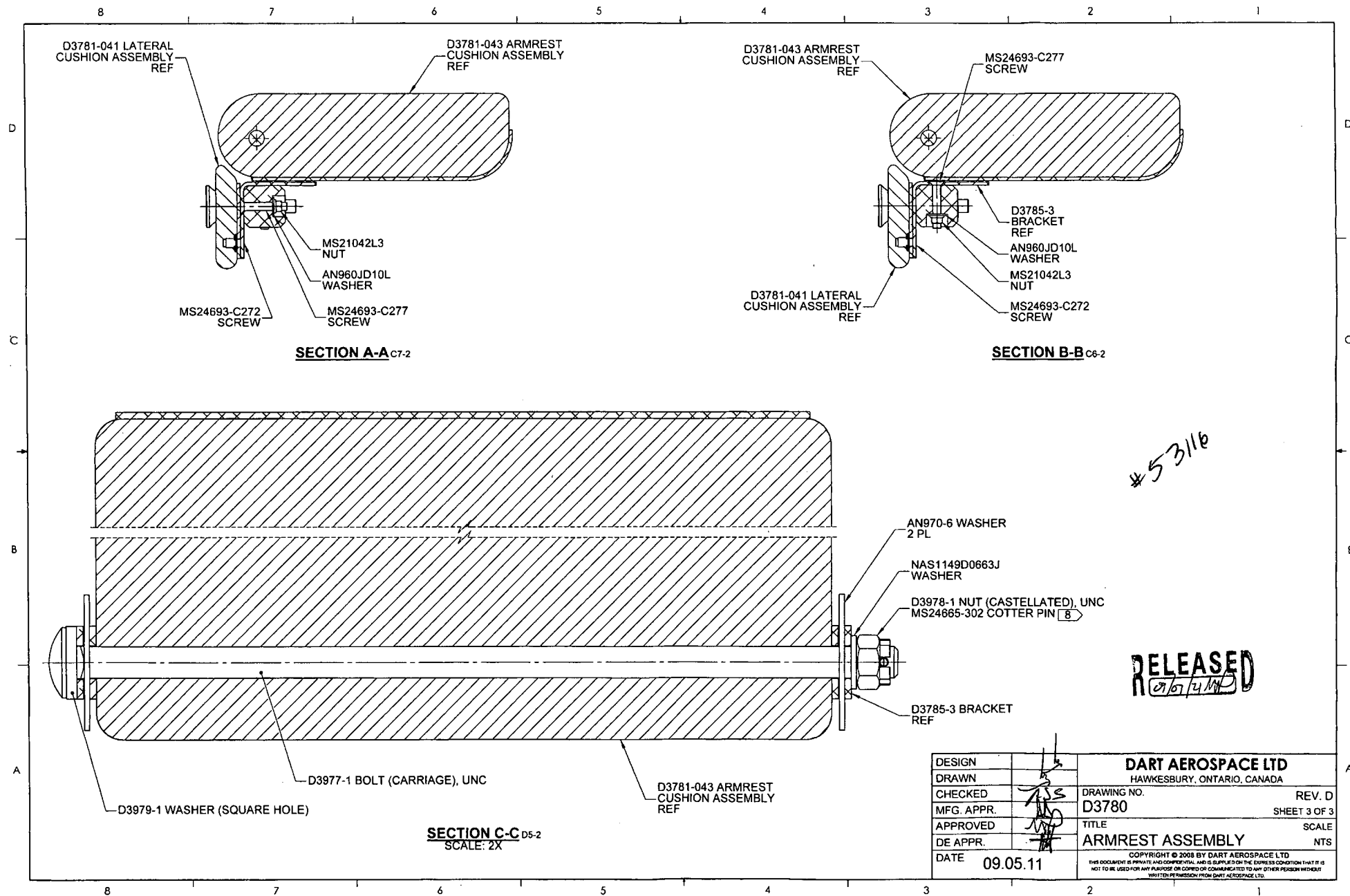
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3780	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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